

Work Order ID 56242

Page 1

Wednesday, February 17, 2010 10:07:06 AM

Item ID: D206-558-041

Accept



Setup Start



Revision ID:

Item Name: Single Cargo Mirror Assembly

Stop



Start Date: 2/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-2-17 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
IIN D206-558	Rev C

100



DOCUMENT CONTROL

0.00

DC



Document Control

Memo

0.00

Photocopy bluefile and type labels as per PPP D206-558-041 CHG008

110



Small Fab

Small Fab

Memo

0.00

Assemble as per Dwg D206-558

120



QC5- Inspect part completeness to step on W/O

QC

Quality Control

Memo

0.00

Pick kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Single Cargo Mirror Assembly

Stop



Start Date: 2/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S. Walter

140



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-558-041

Location: 15PPP Rev: 1

150



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

(0-4-22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

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Parent Item Name: Single Cargo Mirror Assembly

Start Date: 2/18/2010

Required Date: 3/3/2010

Comments: IPP F02.09.19 Re-format; Incorporated D2065 KJ
IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

AN3-4A



Bolt

Purchased No

(125) Each

1,949.000 16.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST	1949	
104214	422	
104291	300	
104322	200	
104374	200	
104625	300	
104817	527	

m109214

AN526-1032R9



Screw

Purchased No

(125) Each

139.0000 16.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST	39	
101189	6	
110584	5	
111758	28	

m114382

Reulysr

AN960JD10



Washer

QSI 017

NAS1149D03631

Purchased No

(110)

100 Each 0.0000 16.0000

EP 10/03/31

M113288 (16X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

AN960JD10L



Washer

Purchased No

(125) A Each

3,457.000 24.0000

10/12/2010

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 3457

101291 16

105793 49

110985 3392

(110) A

Each 8.0000 4.0000

116985

D2011-101



6" Mirror

Manufactured No

(110) A

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 8

53992 8

(110) A

Each 9.0000 8.0000

ES10/03/31

356795 (4x)

D2052



Mounting Bracket

Manufactured No

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST005 9

39556 5

47596 4

ES10/03/31

B56290 (3+)

3 4
3 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

D2054

Manufactured No

(10) A
125

Each

19.0000

4.0000



Mounting Bracket

D2054

Manufactured No

WarehouseLoc QtyLoc Code

Main Warehouse

ST005

19

47595

19

Each

7.0000

8.0000



Bushing

D2055

Manufactured No

*(10) A*Loc QtyLoc Code

Main Warehouse

ST005

7

53179

7

Each

15.0000



Clamp

WarehouseLoc QtyLoc Code

Main Warehouse

ST005

15

55726

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

D2056	Manufactured	No	(10) AA	Each	4.0000	4.0000		EP 10/03/31
-------	--------------	----	---------	------	--------	--------	--	-------------

Bell Crank

Warehouse
Location

Main Warehouse

ST006

4

55598

4

Each

63.0000 4.0000



D2057



Plug

Manufactured No

(10) AA 110

Warehouse
Location

Main Warehouse

ST006

63

34366

42

40048

21

Each

6.0000 4.0000



D2065



Arm

Manufactured No

(10) AA

Warehouse
Location

Main Warehouse

ST

6

41524

6



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

D2067
Manufactured No (125) A Each 32.0000 4.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST6 32

54698 32

Each 7.0000 4.0000

54698B57578 10/4/13 CD2071
Manufactured No (125) A Each 7.0000 4.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST 7

54777 7

Each 5.0000 4.0000

54777 10B5C316 10 Rev 4/8 (4)D3778-1
Manufactured No (125) A Each 5.0000 4.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST 5

45576 5

45576 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

MS21042135

Purchased No

125 AA Each 2,665.000 4.0000

Pro/4/18 (Y)



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	2659	
110844	35	
111274	27	
111668	52	
112314	289	
112385	498	
113523	58	
113537	700	M113537
113644	1000	

Main Warehouse

ST139	6	
111668	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Start Date: 2/18/2010

Required Date: 3/3/2010

Comments: IPP F 02.09.19 Re-format; Incorporated D2065 KJ
IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

MS21042L3



Purchased

No

(110) AA

Each

2,665.000 8.0000



2/10/03/31

Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	2659	
110844	35	
111274	27	
111668	52	
112314	289	
112385	498	
113523	58	
113537	700	
113644	1000	

Main Warehouse

ST139	6	
111668	6	

Each

41.0000 8.0000



8

MS21919-DG5



Purchased

No

(1125) AA

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	41	
110916	41	

114348 x4

M1109/6 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Wednesday, February 17, 2010 10:07:06 AM

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Parent Item Name: Single Cargo Mirror Assembly

Start Date: 2/18/2010

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Comments: IPP F□02.09.19□Re-format; Incorporated D2065□KJ
IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-18

Purchased

No

110

Each

112.0000

8.0000

Screw



Feb 10/03/31

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 112

110916 12

113845 100

Each

104.0000

4.0000

7
1

Feb 10/18 (4)

MS35489-9

Purchased

No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 104

107376 24

109371 80

107376

Grommet



8
1

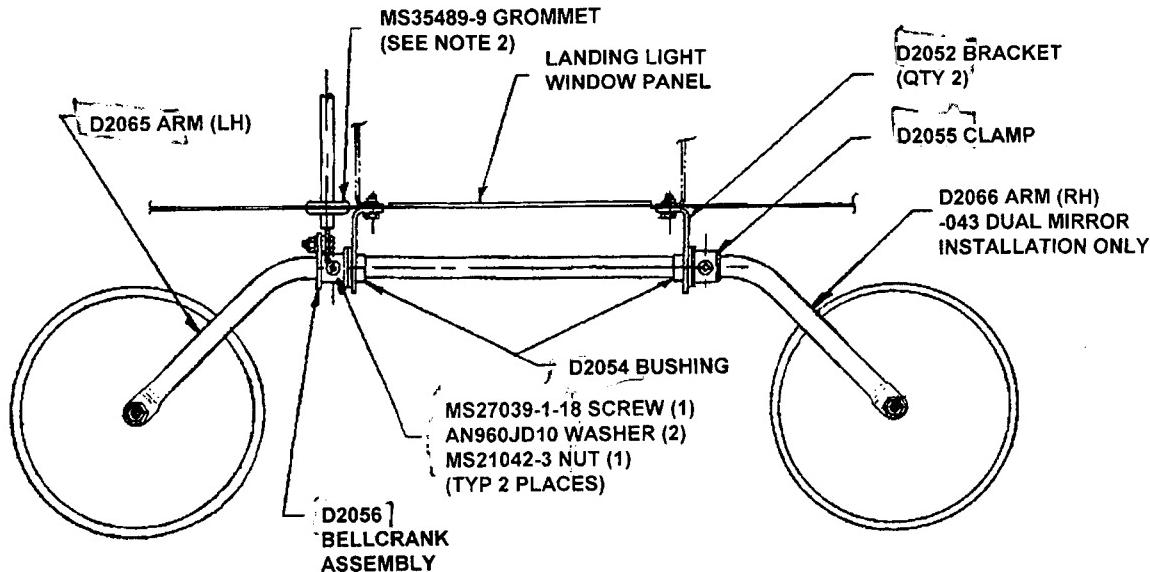
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

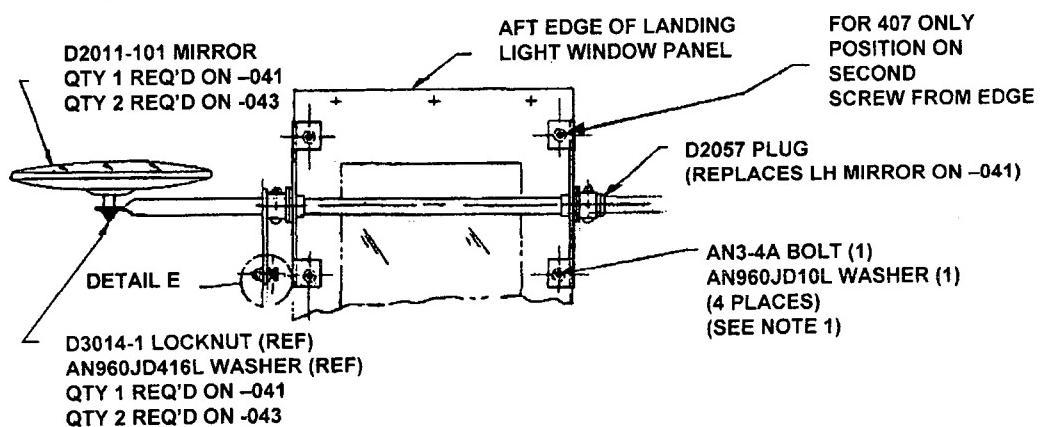
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#56242

**Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)**



**Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)**

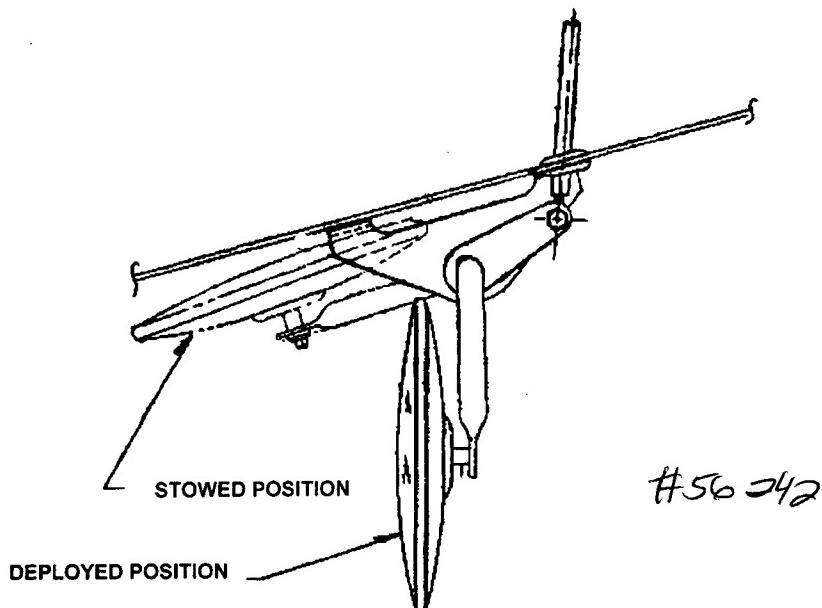
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

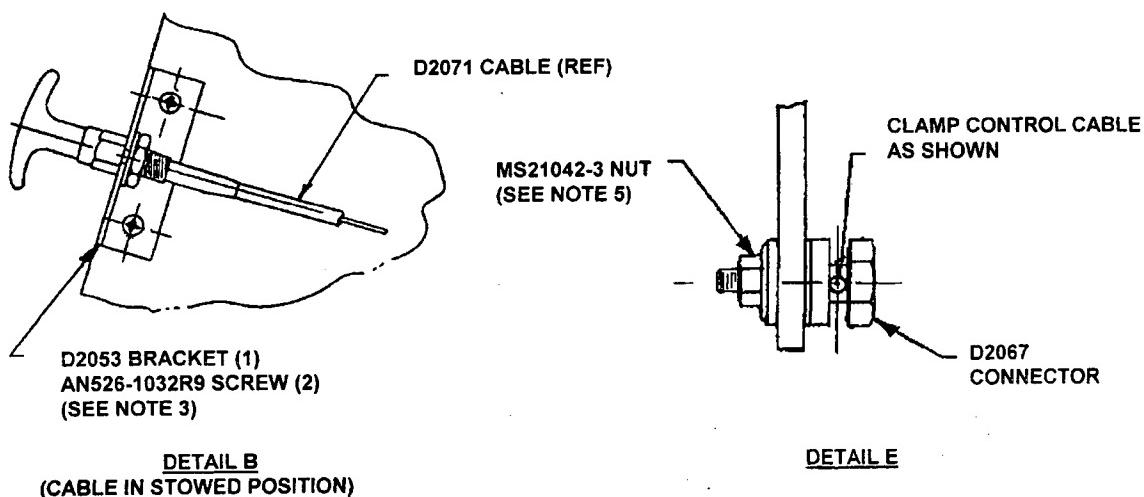
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Figure 25.4 – Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)**



**Figure 25.5 – Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)**

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25.2 CARGO MIRROR REMOVAL

1. Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector.
2. Remove (4) AN3-4A bolts and remove D2052 bracket.
3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
4. Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly.

25.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041 Bell 206A/B/L/L1/L3/L4 Bell 407	2.4 lb 1.09 Kg	+5.0 in +0.13 m	+12.0 in-lb +0.14 m-Kg	+14.8 in +0.38 m	+35.5 in-lb +0.41 m-Kg
D206-558-043 Bell 206A/B/L/L1/L3/L4 Bell 407	3.0 lb 1.36 Kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-Kg	+14.8 in +0.38 m	+44.4 in-lb +0.52 m-Kg

25.4 PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X	D206-558-043	DUAL CARGO MIRROR ASSEMBLY
1	2	D3014-4	* LOCKNUT
1	1	D2071	CABLE ASSEMBLY
2	2	D2054	BUSHING
1	1	D2067	CONNECTOR
	1	D2066	ARM
1		D2065	ARM
1		D2057	PLUG
1	1	D2056	BELLCRANK ASSEMBLY
1	1	D2055	CLAMP
1	1	D2053	BRACKET
2	2	D2052	BRACKET
1	2	D2011-101	MIRROR ASSEMBLY
4	4	AN3-4A	BOLT
4	4	AN526-1032R9	SCREW
1	2	AN960JD416L	* WASHER
4	4	AN960JD10	WASHER
6	6	AN960JD10L	WASHER
3	3	MS21042-3	NUT-(or MS21042L3)
2	2	MS21919DG5	CLAMP
2	2	MS27039-1-18	SCREW
1	1	MS35489-9	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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25-00-00

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

~~REFERENCE ONLY~~

FROM THIS POINT FORWARD, CUSTOMERS SHOULD ORDER D407-558-045/-047 IN LIEU OF D206-558-041/-043 WHEN PROCURING SINGLE/DUAL MIRRORS FOR BHT 407 MODELS. AMEND SECTIONS 4.0 AND 5.0 OF INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER AND 25.3 AND 25.4 OF ICA-D206-558 REV. 0 AS FOLLOWS:

4.0 WEIGHT AND BALANCE (D206-558 REV. C OR EARLIER)

25.3 WEIGHT AND BALANCE (ICA-D206-558 REV. 0)

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041 Bell 206A/B/L1/L3/L4	2.4 lb 1.09 Kg	+5.0 in +0.13 m	+12.0 in-lb +0.14 m-Kg	+14.8 in +0.38 m	+35.5 in-lb +0.41 m-Kg
D206-558-043 Bell 206A/B/L1/L3/L4	3.0 lb 1.36 Kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-Kg	+14.8 in +0.38 m	+44.4 in-lb +0.52 m-Kg
D407-558-045 Bell 407	2.4 lb 1.09 Kg	+5.0 in +0.13 m	+12.0 in-lb +0.14 m-Kg	+14.8 in +0.38 m	+35.5 in-lb +0.41 m-Kg
D407-558-047 Bell 407	3.0 lb 1.36 Kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-Kg	+14.8 in +0.38 m	+44.4 in-lb +0.52 m-Kg

5.0 PARTS LIST (D206-558 REV. C OR EARLIER)

25.4 PARTS LIST (ICA-D206-558 REV. 0)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
2	1	2	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054	BUSHING
4	1	1	1	D2055	CLAMP
1	1	1	1	D2056	BELLCRANK ASSEMBLY
1	1	1	1	D2057	PLUG
4	1	1	1	D2065	ARM
1	1	1	1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1	1	1	D2071	CABLE ASSEMBLY
		1	1	D2071-3	CABLE ASSEMBLY
1	2	1	2	D3014-1	* LOCKNUT
1	1	1	1	D3778-1	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
4	2	1	2	AN960JD416L	* WASHER
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD10L	WASHER
3	3	3	3	MS21042-3	NUT (or MS21042L3)
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
		1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	08.12.04
CERT. NO.:	SH92-17
ISSUE NO.:	7

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9436	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CABLE CHANGE	NTS
DATE	08.12.04	COPRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries